



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2873-043
Job Sheet 187576



Part No: D2873-043

Job Qty: 30 ea

Part Name: Nut Plate Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/7/18

Job Tracking No:

Due Date: 1/31/19

Created By: Jesse White

Type: Stock

Description:

Note: DWG REV A IPP A 05.09.13 New issue KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	30 Ea	1/31/19	1/31/19	0.00	0.00	Start Up Machining-1		gamm 19/01/17
100	Bandsaw	30 pcs	1/31/19	1/31/19	0.00	0.14	Bandsaw1		"
110	CNC Vertical Machining	30 pcs	1/31/19	1/31/19	0.04	7.91	HAAS1-2		mml 19/02/06
120	QC	30 pcs	1/31/19	1/31/19	0.00	0.00	QC2 Machining-1		"
130	QC	30 pcs	1/31/19	1/31/19	0.00	0.00	QC8 Machining-1		S.C.L.
150	QC	30 pcs	1/31/19	1/31/19	0.00	0.00	QC5		19-02-22
160	HandFinish	30 pcs	1/31/19	1/31/19	0.00	0.38	HandFinish1		D.R. 19/2/22 9:39
170	QC	30 pcs	1/31/19	1/31/19	0.00	0.00	QC7-1		36 DAS
180	Small Fab	30 pcs	1/31/19	1/31/19	0.00	1.02	Small Fab-2		9-89 36
190	QC	30 pcs	1/31/19	1/31/19	0.00	0.00	QC5		SC 19/3/04
200	Packaging	30 pcs	1/31/19	1/31/19	0.00	0.00	Packaging3-1		AS 19-3-5
210	QC21-SA	30 Ea	1/31/19	1/31/19	0.00	0.00	QC21		DAS 21 MAR 05 2019

Part Op 100 - Cut blanks: 1.000" x 0.375" x 3.700" long

Descriptions: 110 - Machine as per Folio FA and Dwg D2873 Identify as D2873-3 Dwg Rev A Folio Rev A

180 - 1-Assemble as per Dwg D2873 2-Identify as D2873-043

200 - LOCATION : G050

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.375X1.000	6061T6 Bar .375 X 1.00	9.2490 ft (.3083 ea)	90-Start up Operation	5127976 = 9.42
MS20426AD4-6	Rivet	180 Ea (6 ea)	180-Small Fab	5093088-1
MS21075L5	Nut Plate	90 Ea (3 ea)	180-Small Fab	5142061



Container No: S145879



Part: D2873 - 043

Job No: 187576

Serial No/Batch: S145879

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
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CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 01/17/19

Allocations

Required	Inventory	Allocated
9	21	0
180	1,775	0
90	310	0

Plex 12/7/18 3:31 PM dart.white.jesse

[illegible]

Q3, Q4 Coordinator:

Positioned Wrong
Outside Tolerance

☐	Positioned Wrong
☐	Outside Tolerance
☐	Drawing
☐	Finish
☐	Part Lost/Missing
☐	Misread

Part Specifications

Specifications could not be found.

Plex 12/7/18 3:31 PM dart.white.jesse

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

DART AEROSPACE LTD		Work Order:	
Description: Radius Block		Part Number:	D2873-3
Inspection Dwg: D2873 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.50	+/-0.030	3.500	✓			mm6-05
2.000	+/-0.010	2.00	✓			
0.750	+/-0.010	.756	✓			
1.000	+/-0.010	1.006	✓			
0.250	+/-0.010	.250	✓			
1.000	+/-0.010	1.00	✓			
2.000	+/-0.010	2.00	✓			
3.000	+/-0.010	3.000	✓			
Ø0.128	+0.005/-0.001	.131	✓			
0.359	+/-0.010	.356	✓			
Ø0.316	+0.006/-0.001	.318	✓			
1.000	+/-0.010	1.00	✓			
0.250	+/-0.010	.245	✓			
0.061	+/-0.010	.061	✓			
Ø0.230 x 0.125	+0.005/-0.001 x 0.010	.230 x .125	✓			

Measured by: Date: 19/02/06	Audited by: J.C.L. Date: 19-02-06	Prototype Approval: N/A Date: N/A
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Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue P/O D2873-043	KJ/JLM	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

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